

Work Order ID 75293

October-20-11 9:57:18 AM

75293

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M L J Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3915	C								
100	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
100	Large Fab		<u>m120854</u>				<u>1X</u>		<u>Pl 12.7.30</u>
Large Fab	Memo	0.00							
Large Fab	<p>1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.</p> <p>****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****</p> <p>2- weld hinge, label plate and Mounting plates as per dwg D3915</p>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC	0.00					<u>1</u>	<u>0</u>	<u>12/07/21</u>
Quality Control	Memo								



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		264131					
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00 0.00							
140 *140* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: _____ Memo 1- weld (4) corners	0.00 0.00							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1	0	12/08/01	DAS 18
150									
QC	Memo	0.00							
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
155									
QC	Memo	0.00							
Quality Control	***inspect fit of lid with base***								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									
HandFinish	Memo	0.00							
Hand Finishing	1- realodine corners ***do not acid etch***								

W/O:		WORK ORDER CHANGES					
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N900040100

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

1

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

0.00

- 1- touch up corner with alodine only
- 2- Plug holes prior to

START TIME: 8:45
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:25

in 12,841

*****2nd coat if necessary*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME: _____

0.00

0.00

QC
Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.00							
Hand Finishing	✓ 1- Install webbing as per dwg								
	✓ 2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

DAS 16 9-82 12/08/09

D 4272-014 / B75292

12/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Light Lid Assembly, Long Basket

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Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/8/10 JJ

P1208-9

W/O:		WORK ORDER CHANGES					
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Picklist Print

October-20-11 9:57:22 AM

Page 1

Work Order ID: 75293

75293

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2957

Manufactured

No

100

Each

9.0000

4

4

**

/ *D2957*

Mounting Plate

Location

Loc Qty

Loc Code

WA

9

71221

9

D3915-1

Manufactured

No

100

Each

4.0000

2

2

**

/ *D3915-1*

Rib

Location

Loc Qty

Loc Code

WA

4

63663

0

65321

0

73204

4

D4016-5

Manufactured

No

100

Each

9.0000

3

3

**

/ *D4016-5*

Hinge Half, Light Lid

Location

Loc Qty

Loc Code

WA

6

74468

6

WA005

3

66335

3

PC 12.7.30

B87753 → 4

PC 12.7.30

B83844 → (3)

PC 12.7.30

B87050 → (3)

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Page 2

Work Order ID: 75293

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each 5.0000 3 3

D4019-3

Rib

**

Location

Loc Qty

Loc Code

WA

5

63667

0

68605

5

386449 → ③

D4035-045 Manufactured No

100 Each 1.0000 1 1

D4035-045

Lid Rib Assembly, Fwd (Light)

**

Location

Loc Qty

Loc Code

WA006

1

68545

1

384688 → ①

D4035-047 Manufactured No

100 Each 2.0000 1 1

D4035-047

Lid Rib Assembly, Aft (Light)

**

Location

Loc Qty

Loc Code

WA

2

63669

0

71225

2

B 85936 → ①

D4056-1 Manufactured No

100 Each 3.0000 1 1

D4056-1

Label Plate

**

Location

Loc Qty

Loc Code

WA

3

70338

3

B 5016 → ①

D2728-1 Manufactured No

180 Each 0.0000 1 1

D2728-1

Dart Logo label

**

October-20-11 9:57:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4029-041 Manufactured No

180 Each 3.0000 1 1

D4029-041

Webbing (Long Basket)

**

84412

LocationLoc QtyLoc Code

st503

3

69499

3

MS20600-AD4W3

Purchased No

180 Each 1,415.000 34 34

MS20600-AD4W3

Cherry Rivets

**

M122101

LocationLoc QtyLoc Code

GA

882

118626

882

ST321

400

111636

48

117505

317

117601

35

WA018

133

107939

133

NAS1149DN416J

Purchased No

180 Each 215.0000 34 34

NAS1149DN416.I

Washer

**

M122101 6148/020

LocationLoc QtyLoc Code

ST298

215

114348

11

114597

119

13910

85

October-20-11 9:57:23 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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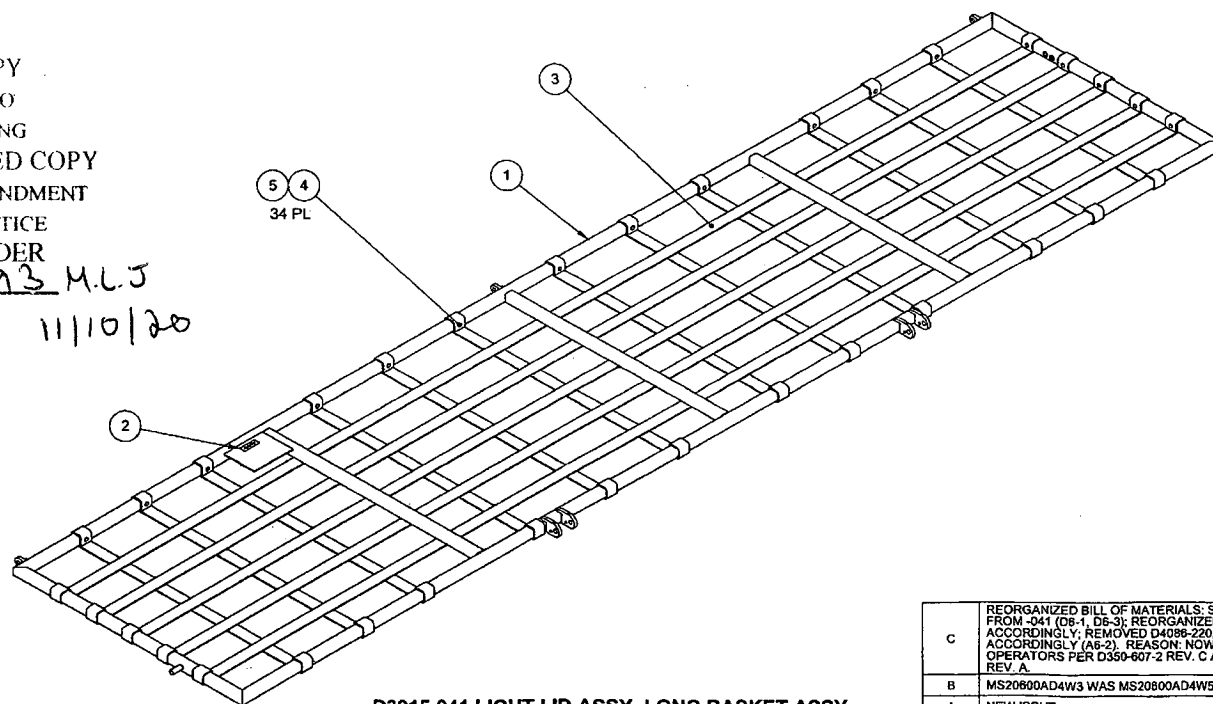
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 35293 M.L.J

11/10/20



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
10-08-12
ECN 10-546

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D8-3); REORGANIZED VIEWS ON SHIT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ALS	DRAWING NO. D3915 REV. C		
CHECKED	ALS	SHEET 1 OF 4		
MFG. APPR.	ALS	TITLE LIGHT LID ASSY-LONG BASKET NTS		
APPROVED	ALS	SCALE		
DE APPR.	ALS	DATE 10.08.05		
<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

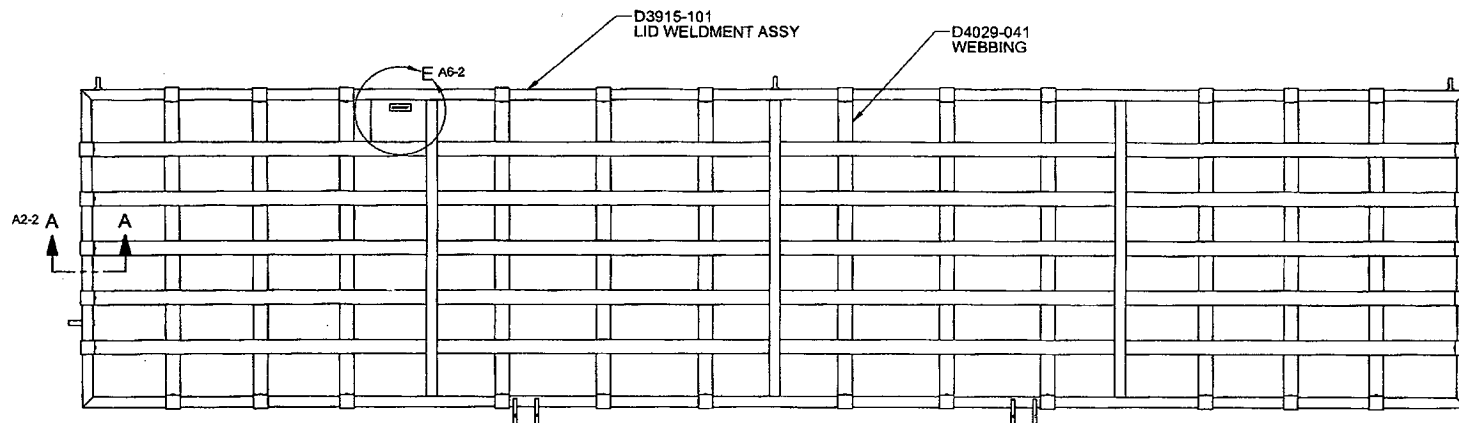
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

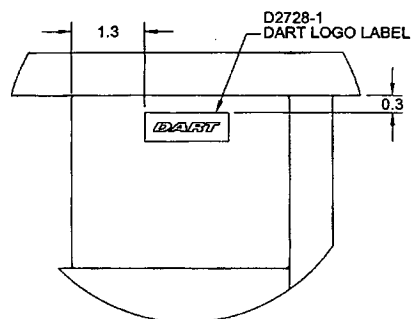
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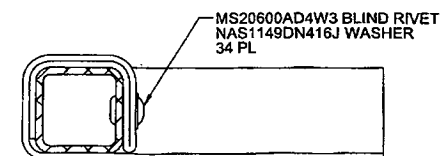
75293



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A	DRAWING NO.	REV. C
CHECKED	SC	D3915	SHEET 2 OF 4
MFG. APPR.	[Signature]	TITLE	SCALE
APPROVED	[Signature]	LIGHT LID ASSY-LONG BASKET	
DE APPR.	[Signature]	NTS	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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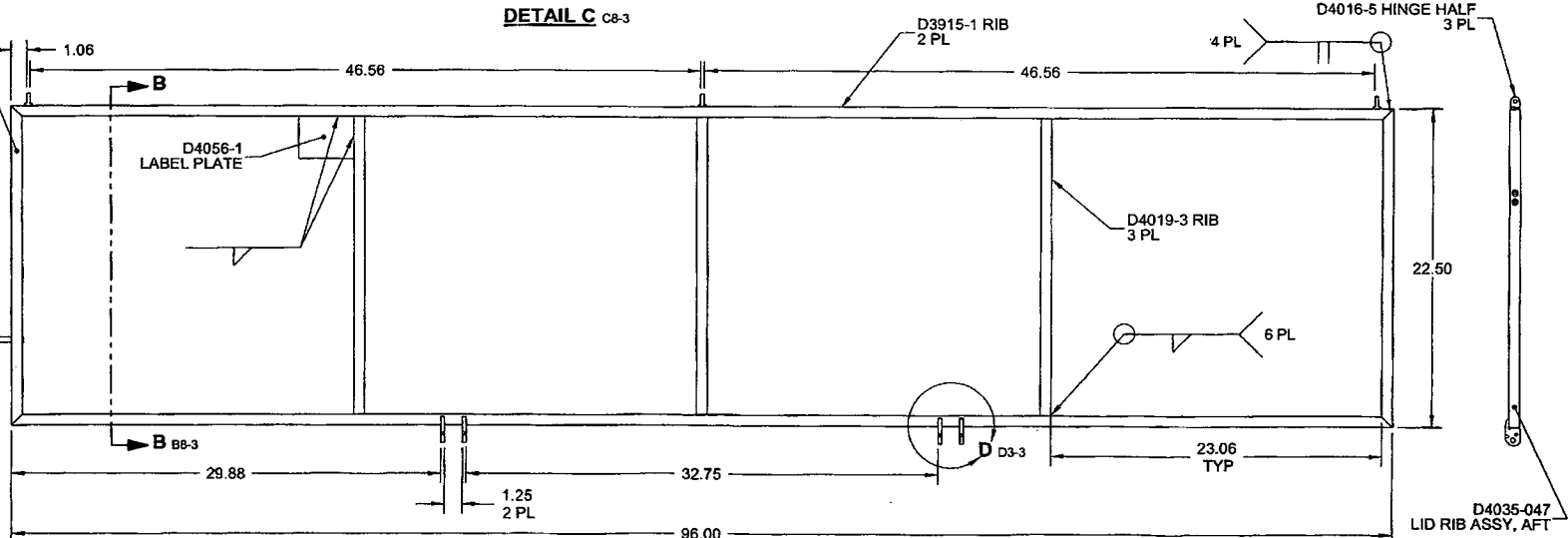
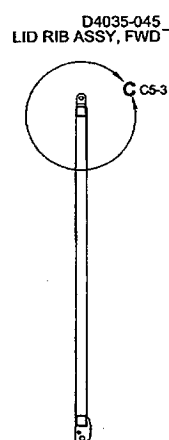
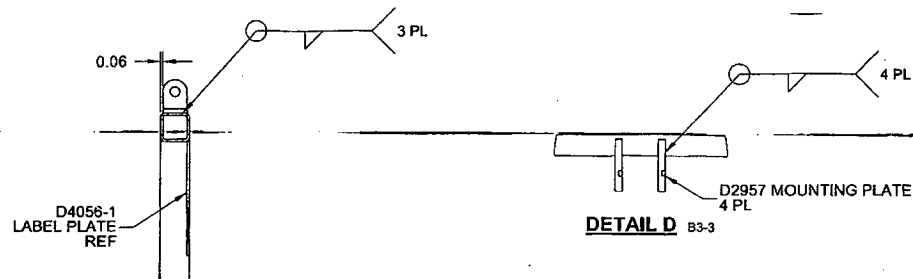
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

DESIGN	4.5	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D3915	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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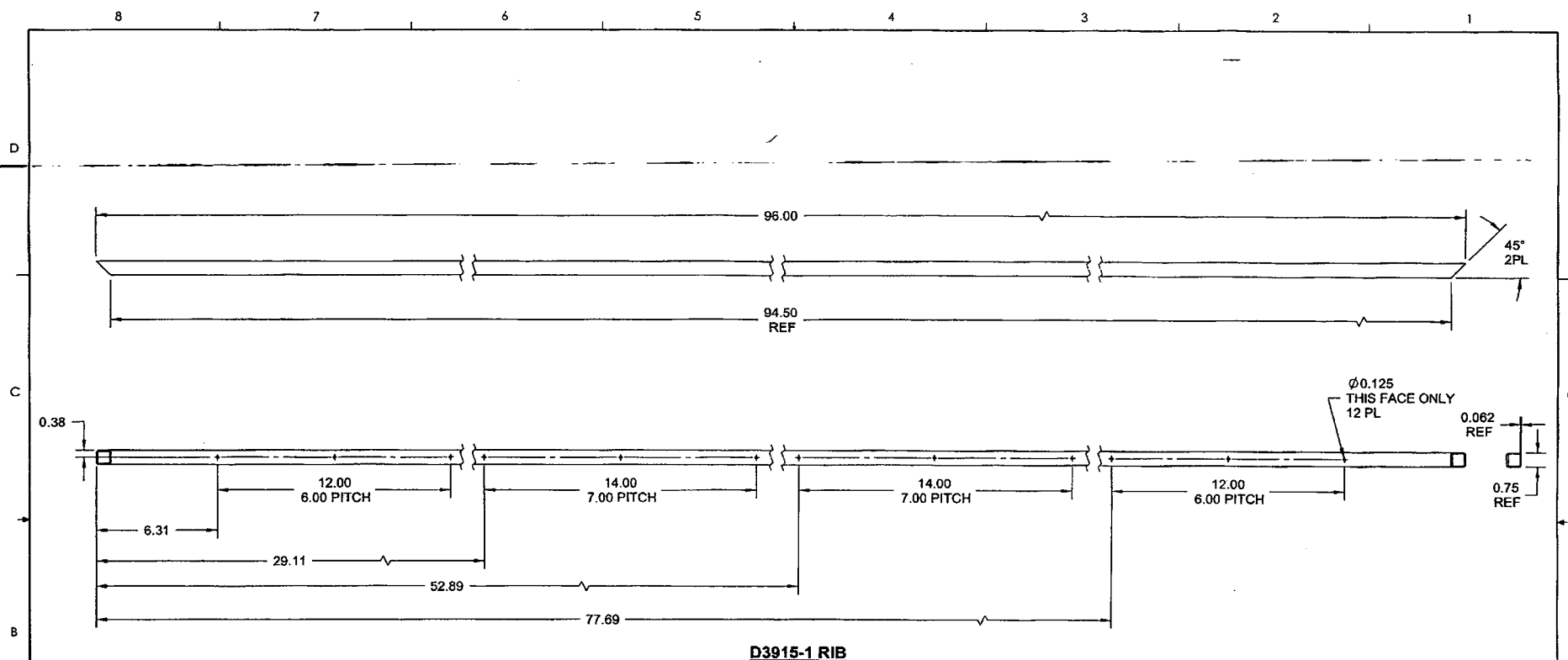
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4180)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

RELEASED
(10-01-12 CP)

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO	REV. C
MFG. APPR.	SC	D3915	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries